

Date: Wednesday, 2/1/2006 11:44:48 AM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|---------------------------------------|--|------------------|-----------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : ARM | |
| Job Number | : 25709 | | Part Number | : D28022 | |
| Estimate Number | : 11028 | | Drawing Number | : D2802 REV A | |
| P.O. Number | : N/A | | Project Number | : N/A | |
| This Issue | : 2/1/2006 S.O. No. : N/A | | Drawing Revision | : A | |
| Prsht Rev. | : NC | | Material | : N/A | |
| First Issue | : N/A | | Due Date | : 2/28/2006 Qty: 8 Um: Each | |
| Previous Run | : N/A | | | | |
| Written By | : See Below | | | | |
| Checked & Approved By | : (X) As 02.01 | | | | |
| Comment | : Est:B 0203.18 Re-format NG | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | | |
|---------|-----------------------|---|-----|----------|
| 1.0 | M6061T6B0500X06000 | 6061-T6 Bar .50" x 6.0" | | |
| | | | | |
| | | Comment: Qty.: 1.5750 f(s)/Unit Total : 12.6000 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 bar 6.00" x 0.50" Batch: M18463 | J-F | 06/02/07 |
| 2.0 | BAND SAW | BAND SAW | | |
| | | | | |
| | | Comment: BAND SAW Cut blanks 17.800" long | J-F | 06/02/07 |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | | |
| | | | | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA101 Counter sink .375 dia as per dwg | J-F | 06/02/08 |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | | |
| | | | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | J-F | 06/02/08 |
| 5.0 | QC8 | SECOND CHECK | | |
| | | | | |
| | | Comment: SECOND CHECK | SA | 06.02.08 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/15
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 2/1/2006 11:44:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 25709

Part Number: D28022

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|-------------------------------|
| 6.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr NO sharp edges.

11.06.02.14 = 8

| | | |
|-----|-----|------------------------------|
| 7.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|-----|----------------|----------------|
| 8.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

N/A

| | | |
|-----|-------------|-----------------------|
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WIA-2

11.06.02.14 8

| | | |
|------|----|------------------|
| 10.0 | DC | DOCUMENT CONTROL |
|------|----|------------------|



Comment: DOCUMENT CONTROL

Inspection Level 21

Sat 06/02/15 (8)

(8) 06/02/15

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|--|----|----------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 06-02-14 | 8 | <p>Powder cart not needed. Stock for welding</p> <p>Remove powder cart.</p> <p>Permanent change.</p> | JM | 06-02-15 | | 06-02-14 | 06-02-14 | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/15
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | | |
|----------------------|-----------------------|---|------------------------|--|
| DESIGN <i>AT</i> | DRAWN BY <i>AT</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>CP</i> | APPROVED <i>CH</i> | DRAWING NO. D2802 | REV. A SHEET 1 OF 1 | |
| DATE 00.11.03 | | TITLE ARM | SCALE 1:3 | |
| A | 00.11.03 | NEW ISSUE | | |

RELEASED
09-11-13 *af*

00-11-13 9

PRESS FIT D2808 SPACER (1)

D2802-041 (SHOWN)
D2802-042 (OPPOSITE)

D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

SHORCOP
RETURNC
ENGINEERED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25709

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| | | |
|--------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | |
| Description: | Part Number: | |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0,500 | | 0,497" | / | | | |
| 0,030R0 | | 0,030R0" | / | | | |
| 0,191Ø | | 0,191Ø" | / | | | |
| 9,358 | | 9,358" | / | | | |
| 1,500 | | 1,502" | / | | | |
| 0,100 | | 0,101" | / | | | |
| 0,250 | | 0,252" | / | | | |
| 0,507Ø | | 0,506" | / | | | |
| 2,033 | | 2,035" | / | | | |
| 0,300R0 | | 0,300R0" | / | | | |
| 1,000" | | 1,000" | / | | | |
| 2,000" | | 2,001" | / | | | |
| 1,347" | | 1,347" | / | | | |
| 0,750R0 | | 0,750R0" | / | | | |
| 4,00 R0 | | 4,00 R0" | / | | | |
| 2,00 R0 | | 2,00 R0" | / | | | |
| 5,541 | | 5,545" | / | | | |
| 0,250 prof | | 0,246" | / | | | |
| 14,776 | | 14,780" | / | | | |
| 0,125 | | 0,1235" | / | | | |
| 0,500 | | 0,505" | / | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J-F. | Audited by: | SA | Prototype Approval: | N/A |
| Date: | 06/02/08 | Date: | 06.02.08 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/RF | |

1907
1908